

Date: Thursday, 12/15/2005 4:05:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PATIENT STOP		
Job Number	: 25271		Part Number	: D2492		
Estimate Number	: 11490		Drawing Number	: D2492 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/15/2005 S.O. No. : N/A		Drawing Revision	: D		
Prsht Rev.	: NC		Material	: MAKE in multiples of 10		
First Issue	: N/A		Due Date	: 12/23/2005		Qty: 10 Um: Each
Previous Run	: N/A			20		
Written By	: SEE COMMENT Below					
Checked & Approved By	: SEE COMMENT Below					
Comment	: Est. E 00.06.26 Removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S080	5052-H32 .080 Sheet	
		Comment: Qty.: 1.9140 sf(s)/Unit Total : 30.6247 sf(s) 5052-H32 .080 Sheet Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M19052	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Shear blanks: 8.000" x 25.942"	J.L 06.02.01 20
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio FA041	J.L 06.02.01 19
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 06.02.01 19
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr Form using Jig DT2492B	DL 06/02/06 19 SAD 06/02/08 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.02.01	3	- 1 part in stack of 10 was cut to short - dimension is $8.000^{+0.030}$ and part is 7.938 didn't machine edges.	 06/02/01	Scrap and destroy	5-L 06.02.01	 06.02.01	 06.02.01	 06.02.01

NOTE: Date & initial all entries

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Drawing Name: PATIENT STOP

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

160209

110

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/02/10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/02/10

119

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 180*

06/02/15

19

19

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

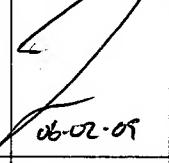
5/15/06/02/16

19

06/02/16

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.02.09	6.1	Add: Addline AS per QSI 005. 4.1 (check for approval) Add to S.P.D. (permanent change) ✓	RE	06.02.16		 06/02/16	 06.02.09	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

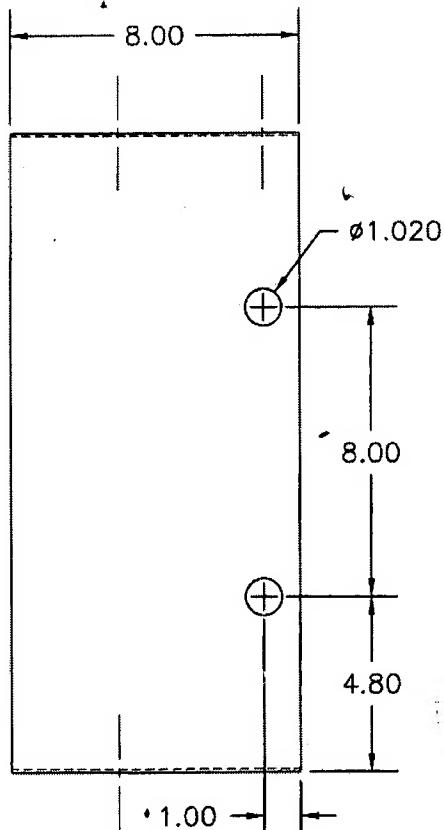
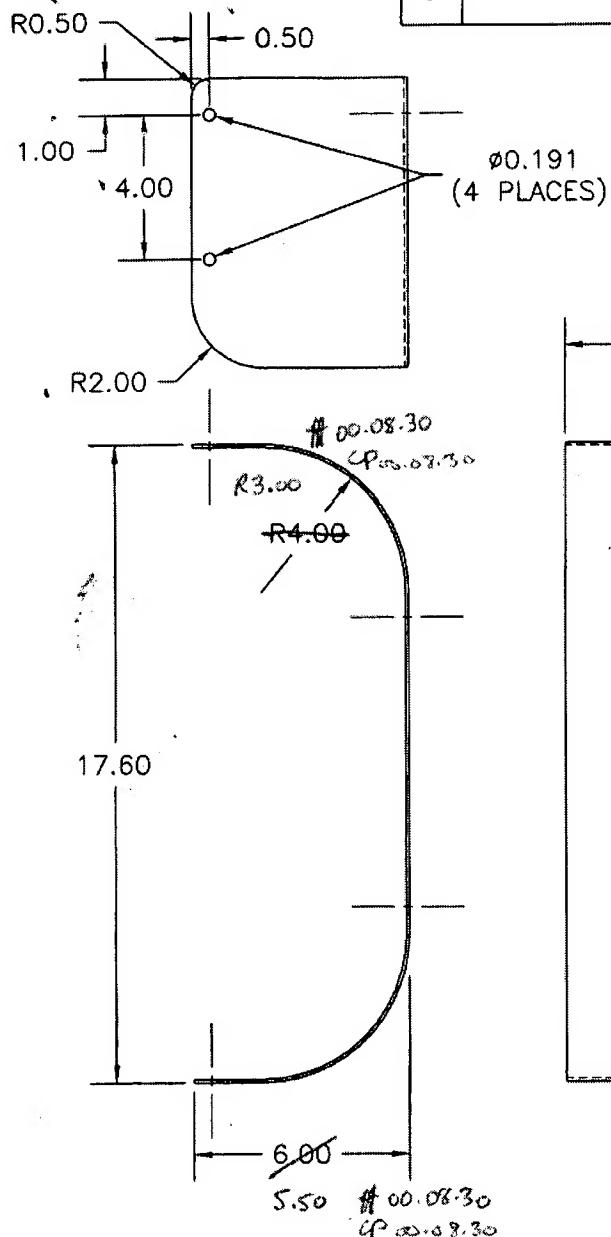
NOTE: Date & initial all entries

DART

10 COPY ISSUE
10

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2492 REV. D SHEET 1 OF 1
DATE		TITLE PATIENT STOP SCALE 1:5
98.05.11		
A	95.10.24	NEW ISSUE
B	96.02.28	MINOR CHANGES
C	97.07.14	CHANGED MATERIAL AND FINISH
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION

RELEASED
98/06/15 KB



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED C
4 OCT 10
25271

MATERIAL: 5052-H32 QQ-A-250/8 0.080 THICK
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

DART AEROSPACE LTD	Work Order:	25271
Description: Patient stop	Part Number:	D2492
Inspection Dwg: D2492 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	J.L	Audited by:	gml	Prototype Approval:	
Date:	06-02-01	Date:	06/02/01	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	